

Date: Monday, 22/09/2008 2:09:06 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CABIN DOOR ROLLER KIT, LH
<b>Job Number</b> :	42195		
<b>Estimate Number</b> :	10276		
<b>P.O. Number</b> :		<b>Part Number</b> :	D412698011
<b>This Issue</b> :	22/09/2008	<b>Drawing Number</b> :	IIN D412-698 REV 8 <i>EGM</i>
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	D
<b>Previous Run</b> :	40223	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	20/10/2008
<b>Checked &amp; Approved By</b> :	<i>JUD 08.9.22</i>	<b>Qty:</b>	22
<b>Comment</b> :	Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*AG for JUD 08.10.08***Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

*S 08/12/0*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3121141	Bracket Assembly
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 66.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 D3121-141

Bracket Assembly

*40250**63**42189**50*

4.0	D3121143	Bracket Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3121-143

Bracket Assembly

*1342190**15**1343486**50*

5.0	D3137043	Bracket Assembly
-----	----------	------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

*1329725**8/12/4**22x**50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/09/2008 2:09:06 PM  
User: Julio Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, LH

Job Number: 42195

Part Number: D412698011

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly

6.0 D3183043

Bracket Assembly



~~16x~~  
42193



8/12/10 SP

Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3183-043

Bracket Assembly

1339862

10  
39924 \*

50

7.0 D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total: 198.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

9 D3199-1

Bracket

1340252

1342223 173X / 8/10/4 SP

8.0 D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3202-1

Cover

1342224

8/12/4

20

50

9.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/12/10 counter X22

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Per B



22x

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-011

Location: 62

8/12/10

50

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/11 JF

Job Completion



mk 08-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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**8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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Revision: E  
Date: 08.05.01